

Work Order ID 152682

Friday, November 04, 2016 10:13:29 AM

152682

Page 1

Item ID: D4364-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Aft

Start Date: 11/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 04 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4364

C

150

0.00

150

Large Fab

Large Fab

Memo

0.38

1- Weld D4365-043 to wearplate as per dwg D4364
304 S.S. Welding Rod
BATCH #: 134992

3- Transfer drill holes in bar

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Quality Control

Memo

0.01

②

16-11-15

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

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Work Center IDOperation
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Run Hours

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Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.01

Quality Control

②

16-11-15

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

Small Fab

Memo

0.02

Small Fab

1- After finish, coat entire top (concave) surface as per note dwg D4364.
TEXTURED COATING B#: 135403

2

DAS
41
9-89

16-11-15

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.01

Quality Control

2

DAS
38
9-89

NOV 17 2016

DQA: _____ Date: _____



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152682

Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Aft

Start Date: 11/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 2.00

2

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Run Start ***NR1***

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SPC (Y/N):

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Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: **FP-002** 0.00***200***

Packaging

Memo

0.00

Packaging

LOCATION : FP002

x 2 **d** **ll** **16/11/17**

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.03

Quality Control

16/11/21 **df**

NOV 17 2016

DAS
21
9-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, November 04, 2016 10:13:36 AM

Page 1
T

Work Order ID: 152682

152682

Parent Item: D4364-043

D4364-043

Parent Item Name: Run-on Landing Wearplate Aft

Start Date: 11/4/2016

Required Date: 11/18/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC IPP
REV:B 14.04.22 DWG B DD VERF:JLM IPP REV:C
15.10.16 PER DWG REV.C1 DD VERF:JLM IPP REV:D 16.06.17
DWG.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4364-3		Manufactured	No				Each	5.0000		2			

D4364-3
Plate

**

16-11-08
JML

Location	Loc Qty	Loc Code
WA002	5	
129884	5	

D4365-043

Manufactured No

Each 0.0000

2

D4365-043
Bar Weldment

**

16-11-08
JML

152684.

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

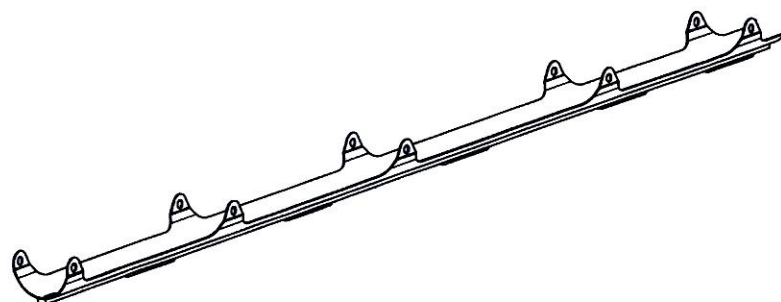
QA Closed: _____ Date: _____

Work Order update only ☐

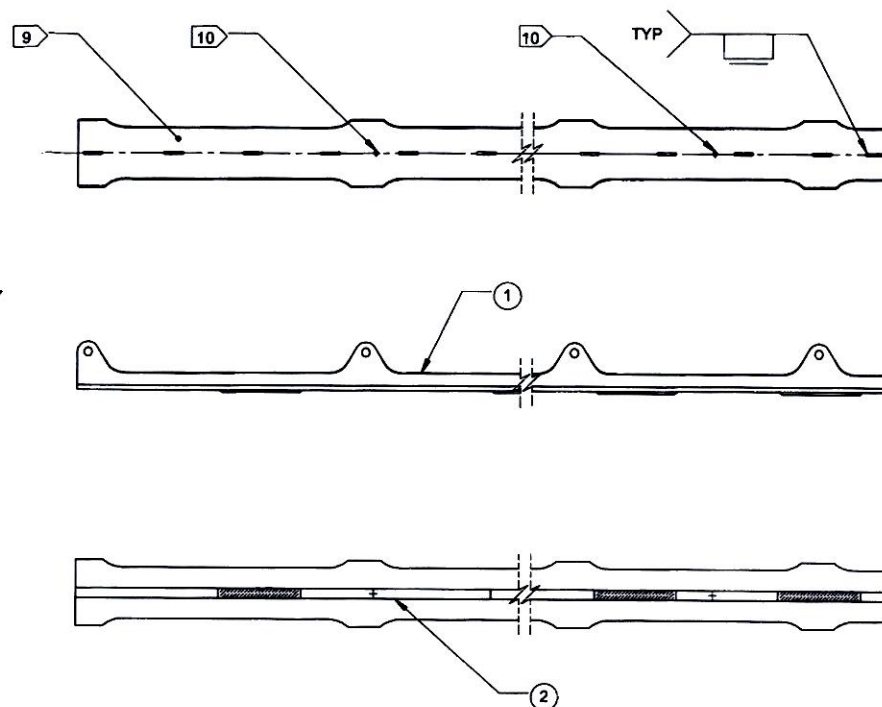
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-043	WEARPLATE ASSY
1	1	D4364-3	PLATE
2	1	D4365-043	BAR WELDMENT

△ C



D4364-043 AFT WEARPLATE ASSY △ C



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152682 MLJ
10-11-04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-043" PER QSI 044 6.1
- 7) WEIGHT: 5.88 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4365-043 BAR WELDMENT FROM D4364-3 WEARPLATE AFTER WELDING

RELEASED
2016-06-16

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	